

Date: Friday, 18/07/2008 2:42:08 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	HELI ACCESS STEP EXT HIGH GEAR
<b>Job Number</b> :	40669		
<b>Estimate Number</b> :	12874		
<b>P.O. Number</b> :		<b>Part Number</b> :	D205633025
<b>This Issue</b> :	18/07/2008	<b>Drawing Number</b> :	DSI 9300 REV B
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	1/1	<b>Drawing Revision</b> :	B
<b>Previous Run</b> :	34975	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	28/07/2008
<b>Checked &amp; Approved By</b> :	JLD 08.7.18	<b>Qty:</b>	2 Um: Each
<b>Comment</b> :	Est Rev:B Added D3165-1 KJ/JLM 05-09-09		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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JLD 08.7.23



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPPD205-633-025

CHG001

5.02/7/23

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2022101	Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Spacer

Batch: 37521

LC

4.0	D2022103	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer

Batch: 35885

LC

5.0	D2562005	Strut
-----	----------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Strut

Batch: 23224

LC 5/2/23 @

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Job Number: 40669

Part Number: D205633025

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 D2563 Step Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Step Weldment Assembly

Batch: 23207 26230

23246

20935A

7.0 D31651 Support Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support Arm

Batch: 23234

8.0 D2565301 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: 20848 1x 20608 1x

9.0 D2565303 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: 20849

10.0 D2565305 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: 20850 1x 20610 1x

11.0 D2565307 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: 20851 1x 20611 1x

12.0 D2565309 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: 20F52

C 8/7/23 (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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## Process Sheet

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Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Job Number: 40669

Part Number: D205633025

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 D3437045 Aft Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Aft Strut Assembly

Batch: 40672

14.0 AN45A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M15247

15.0 AN46A Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Batch: M107534

16.0 AN47A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M16199

17.0 AN412A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M105143

18.0 AN414A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M14600

19.0 AN44 7A EYEBOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

EYEBOLT

Batch: M1076 68

\*\*\*\*\*ENSURE THIS IS AN44-7A EYEBOLT\*\*\*\*\*

8/7/23 (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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## Process Sheet

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Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Job Number: 40669

Part Number: D205633025

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN514A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M17566 1x M11921 1x CU

21.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Batch: M103691 20 M107935 84 CU

22.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch: 16527 CU

23.0

MS21042L4

Nut



Comment: Qty.: 7.0000 Each(s)/Unit Total : 14.0000 Each(s)

Nut

Batch: M15924 24 M102552 124 CU

24.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M16941 2x M19073 2x CU 8/7/23 (2)

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-025

Location: DRAFT CU 8/7/23 (2)

PPP Rev: DRAFT CU 8/7/23 (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



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Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Job Number: 40669

Part Number: D205633025

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/24 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-24

<b>DART</b>			
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D205-633-015	CHG	CHG002
DESC.	Heli-Access-Step	STC	SH96-57
LOT	B23207	STC	SR00592/3NY
MODEL	Bell 205/212/214/412	STC	SR00594NY
MADE IN CANADA			

<b>DART</b>			
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D205-633-015	CHG	CHG002
DESC.	Heli-Access-Step	STC	SH96-57
LOT	B26230	STC	SR00592/3NY
MODEL	Bell 205/212/214/412	STC	SR00594NY
MADE IN CANADA			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSI 9300	REV. B SHEET 1 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS
A	05.05.05	NEW ISSUE	
B	05.08.12	ADD STRUTS IF TANK REMOVED	

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-633 REV. A

REF. CANADIAN STC: SH96-57

REF. FAA STC: SR00592NY, SR00593NY, SR00594NY

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO ADD THE D205-633-021/-022/-023/-024/-025/-026 STEPS TO ADDRESS COMPATABILITY WITH THE SIMPLEX MODEL 304 FIRE ATTACK TANK. D205-633-021/-022 ARE IDENTICAL TO D205-633-011, EXCEPT AS SHOWN HERE. D205-633-023/-024 ARE IDENTICAL TO D205-633-013, EXCEPT AS SHOWN HERE. D205-633-025/-026 ARE IDENTICAL TO D205-633-015, EXCEPT AS SHOWN HERE.

NOTE THAT THE STRUTS REQUIRED TO INSTALL THE STEPS ON THE LOWER AFT HARDPOINT HAVE ALSO BEEN INCLUDED WITH THE KITS IN CASE THE TANK IS REMOVED FOR ANY REASON. THESE STRUTS SHOULD BE INSTALLED I.A.W. IIN-D205-633, EXCEPT REPLACE EYEBOLT WITH AN4 BOLT ON LOWER HARDPOINT. ALSO NOTE THAT IF THE THREADS PROTRUDE THROUGH THE BAR ON THE D3437-XXX STRUT ASSEMBLIES AFTER ADJUSTMENT THEY MAY BE TRIMMED OFF.

### WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-633-021 <i>HELI-ACCESS-STEP™</i>	14.0 lb 6.35 kg	-50.0 in -1.27 m	-700 in-lb -8.06 m-kg	94.5 in 2.40 m	1323 in-lb 15.24 m-kg
D205-633-022 <i>HELI-ACCESS-STEP™</i>	13.2 lb 6.00 kg	+50.0 in +1.27 m	+660 in-lb +7.62 m-kg	94.5 in 2.40 m	1247 in-lb 14.40 m-kg
D205-633-023 <i>HELI-ACCESS-STEP™</i>	14.3 lb 6.50 kg	-50.0 in -1.27 m	-715 in-lb -8.26 m-kg	94.5 in 2.40 m	1351 in-lb 15.6 m-kg
D205-633-024 <i>HELI-ACCESS-STEP™</i>	13.5 lb 6.14 kg	+50.0 in +1.27 m	+675 in-lb +7.80 m-kg	94.5 in 2.40 m	1276 in-lb 14.74 m-kg
D205-633-025 <i>HELI-ACCESS-STEP™</i>	14.6 lb 6.64 kg	-50.0 in -1.27 m	-730 in-lb -8.43 m-kg	94.5 in 2.40 m	1380 in-lb 15.94 m-kg
D205-633-026 <i>HELI-ACCESS-STEP™</i>	13.8 lb 6.27 kg	+50.0 in +1.27 m	+690 in-lb +7.96 m-kg	94.5 in 2.40 m	1304 in-lb 15.05 m-kg

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BRANCH  
DAO # 01-O-01

**APPROVED**



BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 05.08.12  
CERT. NO.: SH96-57  
ISSUE NO.: #5

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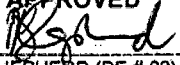
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DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS

**PARTS LIST**

QTY -021	QTY -022	QTY -023	QTY -024	QTY -025	QTY -026	Part Number	Description
X						D205-633-021	Hel-Access-Step™ (LH), High Gear
	X					D205-633-022	Hel-Access-Step™ (RH), High Gear
		X				D205-633-023	Hel-Access-Step™ (LH), Extended High Gear (31")
			X			D205-633-024	Hel-Access-Step™ (RH), Extended High Gear (31")
				X		D205-633-025	Hel-Access-Step™ (LH), Extended High Gear (39")
					X	D205-633-026	Hel-Access-Step™ (RH), Extended High Gear (39")
4	4	4	4	4	4	D2022-101	SPACER
2	2	2	2	2	2	D2022-103	SPACER
				1	1	D2562-005	STRUT
1	1					D2562-011	STRUT
		1	1			D2562-013	STRUT
1		1		1		D2563	WELDMENT ASSEMBLY
				*1	*1	D3165-1	STRUT
1	1					D2565-101	STRUT
1	1					D2565-103	STRUT
1	1					D2565-105	STRUT
1	1					D2565-107	STRUT
1	1					D2565-109	STRUT
*1	*1					D2565-111	STRUT
		1	1			D2565-201	STRUT
		1	1			D2565-203	STRUT
		1	1			D2565-205	STRUT
		1	1			D2565-207	STRUT
		1	1			D2565-209	STRUT
		*1	*1			D2565-211	STRUT
				1	1	D2565-301	STRUT
				1	1	D2565-303	STRUT
				1	1	D2565-305	STRUT
				1	1	D2565-307	STRUT
				1	1	D2565-309	STRUT
1	1					D3437-041	AFT STRUT ASSEMBLY
		1	1			D3437-043	AFT STRUT ASSEMBLY
				1	1	D3437-045	AFT STRUT ASSEMBLY
	1		1		1	D3438-042	WELDMENT ASSEMBLY
1	1	1	1	1	1	AN4-5A	BOLT
4	4	3	3	3	3	AN4-6A	BOLT
1	1	1	1	1	1	AN4-7A	BOLT
1	1					AN4-11A	BOLT
		1	1	1	1	AN4-12A	BOLT
1	1	1	1	1	1	AN4-14A	BOLT
1	1	1	1	1	1	AN44-7A	EYEBOLT
1	1	1	1	1	1	AN5-14A	BOLT
16	16	14	14	14	14	AN960JD416	WASHER
3	3	3	3	3	3	AN960JD516	WASHER
8	8	7	7	7	7	MS21042L4	NUT (or MS21042-4)
2	2	2	2	2	2	MS21042L5	NUT (or MS21042-5)

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APPROVED  
  
BY: D. SHEPHERD (DE # 02)  
DATE: 05.08.12  
CERT. NO.: SH96-57  
ISSUE NO.: #5

\* ONLY INSTALLED IF TANK IS REMOVED

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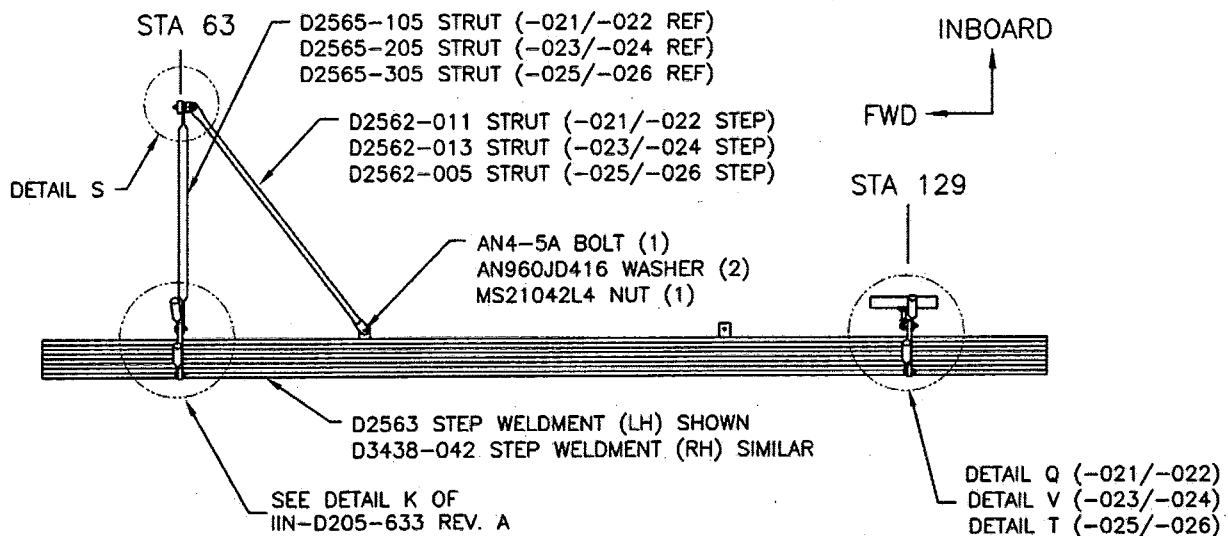
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B 3 OF 6
DATE 05.08.12	TITLE SIMPLEX TANK STEP KIT		SCALE NTS

**INSTALLATION OF D205-633-021/-022/-023/-024/-025/-026**

INSTALL D205-633-021/-022 AS PER THE D205-633-011 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-111 STRUT WITH THE D3437-041 AFT STRUT ASS'Y, REMOVE D2562-001 STRUT, INSTALL D2562-011 STRUT AS SHOWN.

INSTALL D205-633-023/-024 AS PER THE D205-633-013 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-211 STRUT WITH THE D3437-043 AFT STRUT ASS'Y, REMOVE D2562-003 STRUT, INSTALL D2562-013 STRUT AS SHOWN.

INSTALL D205-633-025/-026 AS PER THE D205-633-015 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D3165-1 SUPPORT ARM WITH THE D3437-045 AFT STRUT ASS'Y AS SHOWN.

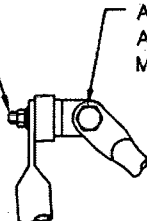
**D205-633-021/-023/-025 SHOWN.****D205-633-022/-024/-026 SIMILAR**

(VIEW LOOKING DOWN)

AN44-7A EYEBOLT (1)  
AN960JD516 WASHER (1)  
MS21042L5 NUT (1)

AN4-6A BOLT (1)  
AN960JD416 WASHER (2)  
MS21042L4 NUT (1)

**DETAIL S**  
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BY: *[Signature]*  
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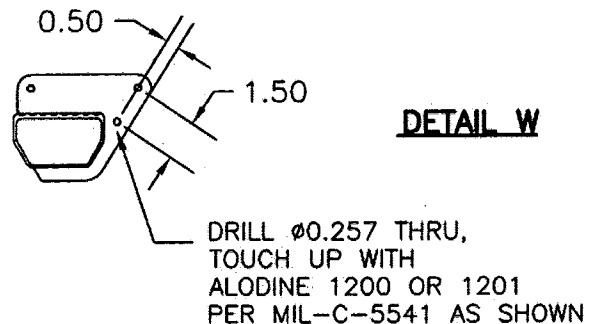
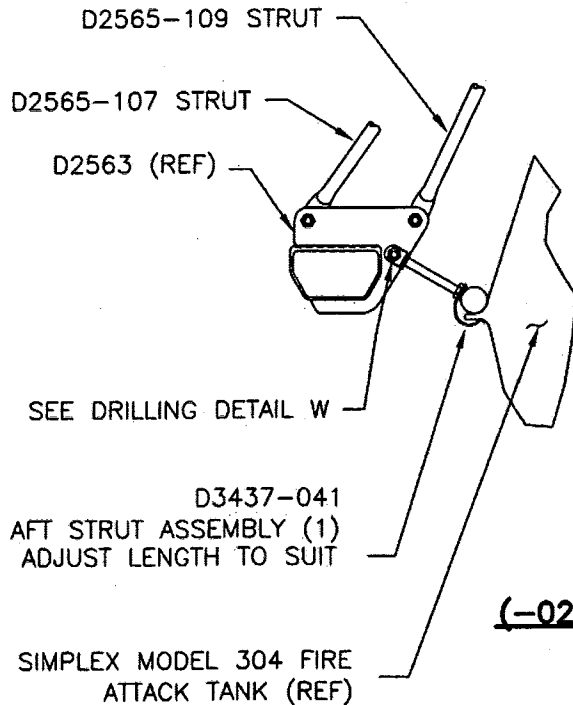
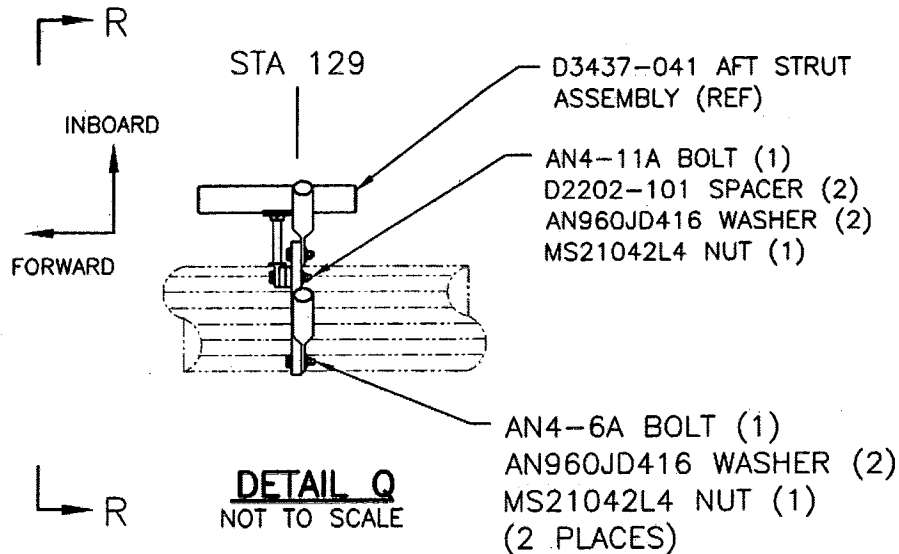
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DATE 05.08.12	TITLE SIMPLEX TANK STEP		SCALE NTS



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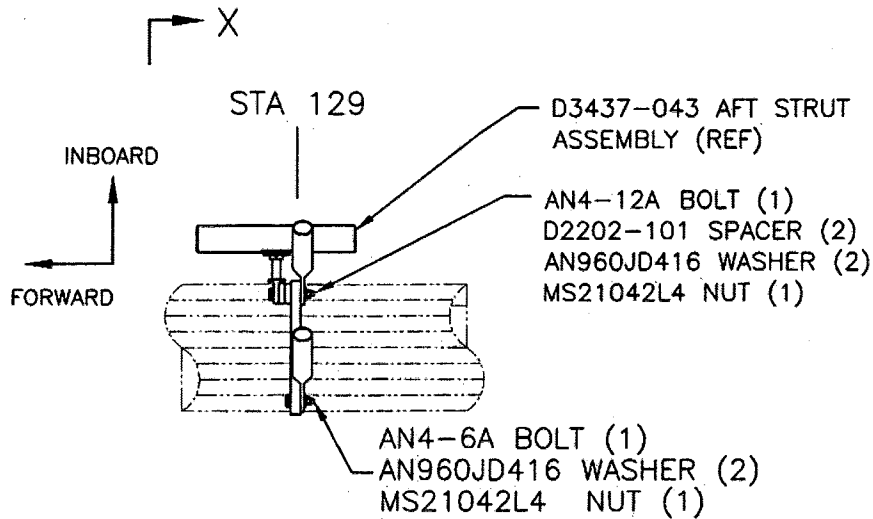
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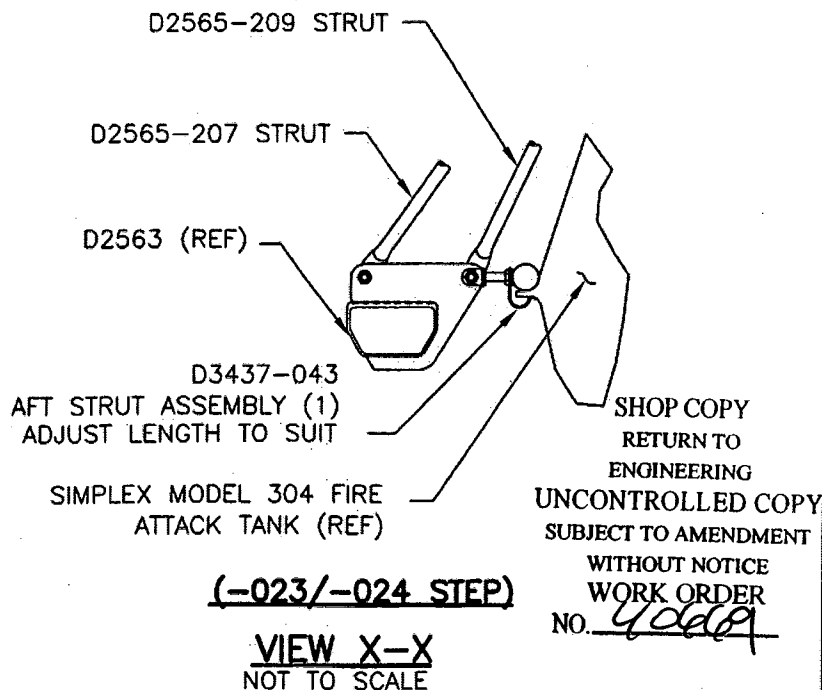
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DATE 05.08.12	TITLE SIMPLEX TANK STEP		SCALE NTS



**DETAIL V**  
NOT TO SCALE



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BRANCH  
DAO # 01-O-01

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BY: *[Signature]*  
D. SHEPHERD (DE # 02)

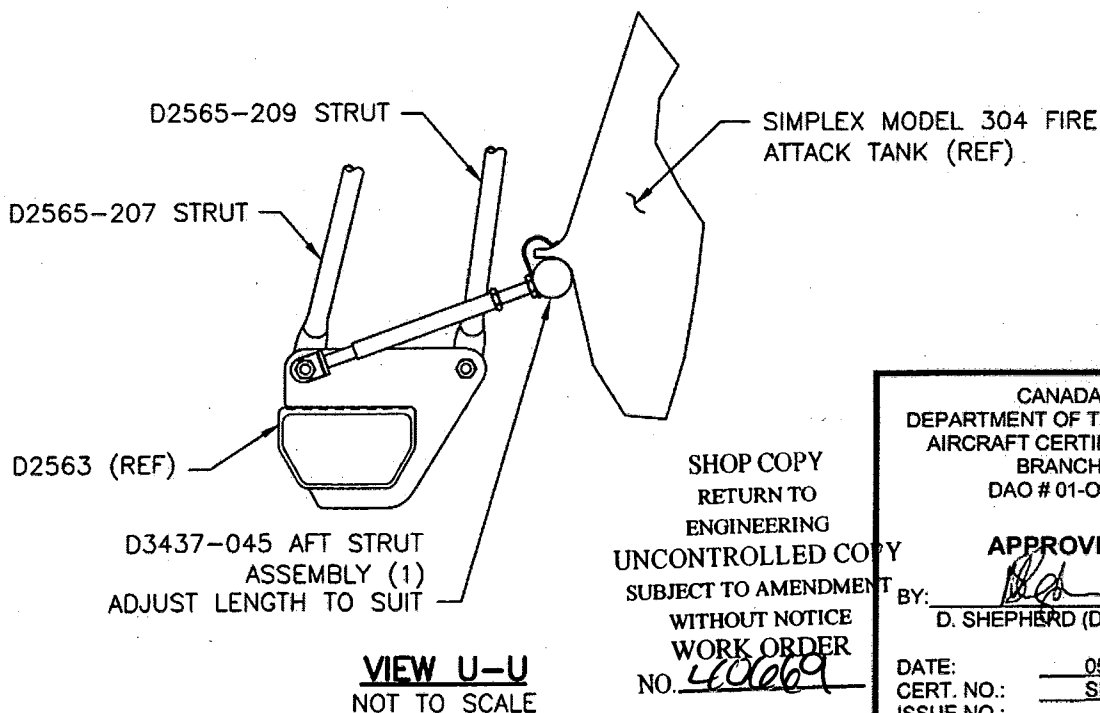
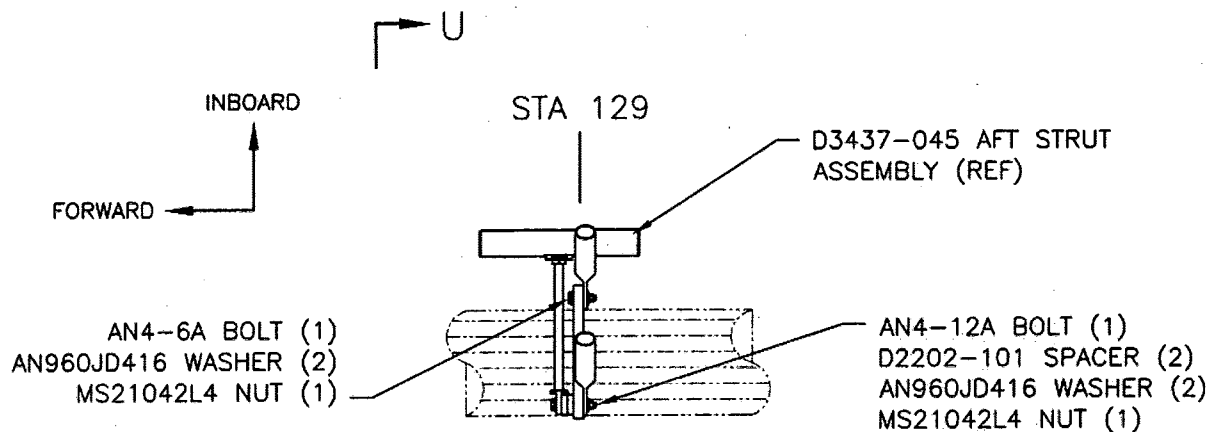
DATE: 05.08.12  
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ISSUE NO.: #5

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